

ABSTRACT OF THE DISCLOSURE

A threading control method and apparatus therefor is provided, in
5 which, when carrying out thread-cut machining operations several times at
one position, synchronized with main-spindle rotation and controlling
movement of a threading spindle, deviations in thread grooves are
prevented without correcting programmed commands, machining accuracy
is improved, and tool life extended.

10 When a main-spindle single-rotation reference signal and a
main-spindle position counter are input to the numerical control apparatus,
the present main-spindle position is computed by a main-spindle position
computing means 103, the difference between the main-spindle
single-rotation reference signal and control cycles is obtained, as a
15 correction amount 108, from the computed main-spindle position, by a
main-spindle position-correcting means 104 and a correction is done. A
threading-spindle interpolation starting detection means 105 monitors
whether the main-spindle single-rotation reference signal and the control
cycles are synchronous, and when synchronous, interpolation for the
20 threading spindle is started by interpolation means 106 for each spindle.